

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2016-126 Date Opened: 20-Sept-16 Title: FabricationAircraft OEM: Bell Aircraft Model: 429 Product Type: Fittings Product Model: Post S/N 81 Quantity: 3 sets**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95940	0	Lug Fabrication	JC

Traveller

Cut stock
Turn 1 end flat
Machine socket
Turn rounded end
Machine angled lug
Anodize

Initial or N/A

DB
JC
JC
DM
DM
JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

3 sets
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
JC
N/A
N/A
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: David MartynSign: [Signature]SCA: AD05Date: 06-Oct-16

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD01Date: 07-Oct-16

Work Order closed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 13-Oct-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LUG / PLUG No. of pieces: 18

Manufacturer: AERO DESIGN

Part No.: SEE REMARKS Serial/Batch No.: PO 15052

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: ANODIZING

Signature: JH Chh.

Date: 03 OCT 2016 Lic. No. / SCA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

95940-01 x3

95940-02 x3

95940-03 x3

95940-04 x3

95940-05 x3

95940-06 x3



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Plate No. of pieces: 12

Manufacturer: Aero Design Ltd

Part No.: 95942-02 Serial/Batch No.: 16003

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: Anodizing

Signature: [Signature]

Date: Sept 30th / 2016 Lic. No. / SCA AD-07

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Plate No. of pieces: 12

Manufacturer: Aero Design Ltd

Part No.: 95942-01 Serial/Batch No.: 16003

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: Anodizing

Signature: [Signature]

Date: Sept 30th 2016 Lic. No. / SCA AD-07

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

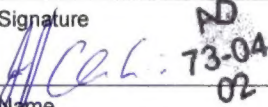
AMF 73-04

In Process

Remarks

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0460
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-126
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward RH Lug	95940-01	1	N/A	New
2.	Forward LH Lug	95940-02	1		
3.	Aft RH Lug	95940-03	1		
4.	Aft LH Lug	95940-04	1		
5.	Centre RH Plug	95940-05	1		
6.	Centre LH Plug	95940-06	1		
12. Remarks Corrected Work Order from WO 2017-126 to WO 2016-126					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 8 Dec 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Bell Helicopters

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0460
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice 2016 C15 WO 2017-126	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward RH Lug	95940-01	1	N/A	New
2.	Forward LH Lug	95940-02	1		
3.	Aft RH Lug	95940-03	1		
4.	Aft LH Lug	95940-04	1		
5.	Centre RH Plug	95940-05	1		
6.	Centre LH Plug	95940-06	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 7 Dec 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

Bell Helicopters



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: CEN RH PLUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-05 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: [Signature] AD

Date: 07 OCT 2016 Lic. No. / SCA 73-04

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

Serviceable

MATERIAL PO 15052

ANODIZE PO 16069

1x Removed 11 OCT 2016 JK.

1x removed 29 Sept 2017 JC.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD LH LUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-02 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: [Signature] C.R.L. AD

Date: 07 OCT 2016 Lic. No. / SCA 73-04

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

MATERIAL PO 15052

ANODIZE PO 16069

1x Removed 11 OCT 2016 GC.

1x Removed 29 Sept 2017 GC.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: FWD RH LUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-C1 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 07 OCT 2016 Lic. No. / SCA 73-04 02

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

Serviceable

MATERIAL PO 15052

ANODIZE PO 16069

1x Removed 11 OCT 2016 JC

1x Removed 29 Sept 2017 JC



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: CEN LH PLUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-06 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: [Signature] NO

Date: 07 OCT 2016 Lic. No. / SCA 73-04
02

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

MATERIAL PO 15052

ANODIZE PO 16069

1x removed 11 OCT 2016 JC

1x removed 29 Sept 2017 JC



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT RH LUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-03 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: Jff Cerh.

Date: 07 OCT 2016 Lic. No. / SCA 73-04 02

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

MATERIAL PO 15052

AN-DIZE PO 16069

1x Removed 11 OCT 2016 JK

1x Removed 29 Sep 2017 JK.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT LH LUG No. of pieces: 3

Manufacturer: AERO DESIGN

Part No.: 95940-04 Serial No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-126

Remaining Tasks to be Performed: NONE

Signature: [Signature] AD

Date: 07 OCT 2016 Lic. No. / SCA 73-04
02

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Serviceable

Remarks

MATERIAL PO 15052


ANODIZE PO 16069

1 x Removed 11 Oct 2016 JC

1 x Removed 28 Sept 2017 JC

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0379
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice WO 2016-126	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward RH Lug	95940-01	1	N/A	New
2.	Forward LH Lug	95940-02	1		
3.	Aft RH Lug	95940-03	1		
4.	Aft LH Lug	95940-04	1		
5.	Centre RH Plug	95940-05	1		
6.	Centre LH Plug	95940-06	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 02 Oct 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HANGAR ONE

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0197
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice WO 2016-126	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Forward RH Lug	95940-01	1	N/A	New
2.	Forward LH Lug	95940-02	1		
3.	Aft RH Lug	95940-03	1		
4.	Aft LH Lug	95940-04	1		
5.	Centre RH Plug	95940-05	1		
6.	Centre LH Plug	95940-06	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 11 Oct 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

BELL HELICOPTER

Aero Design

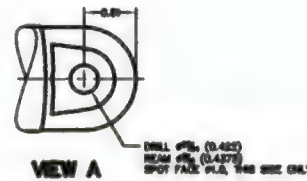
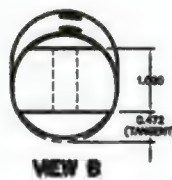
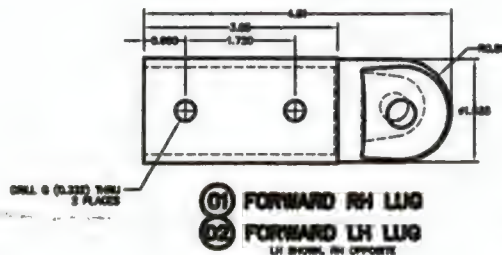
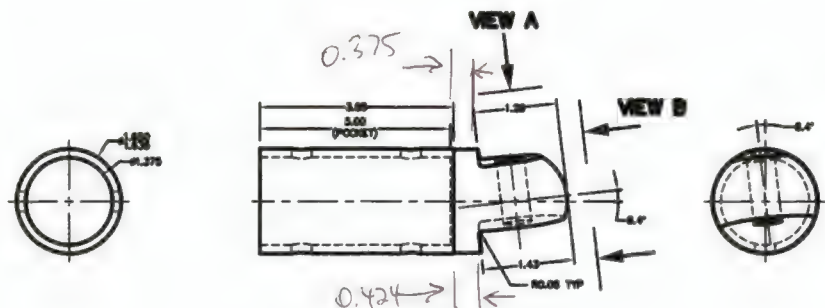
Parts Distribution Sheet

Description: 429 Fittings

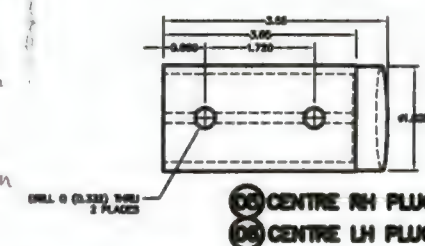
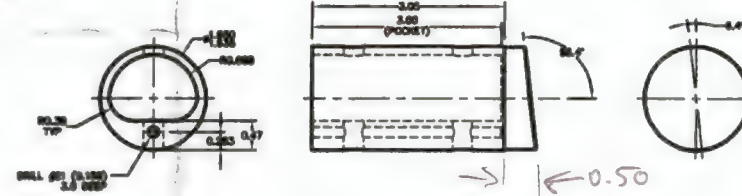
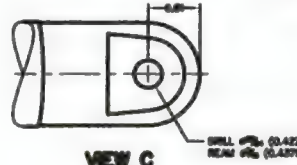
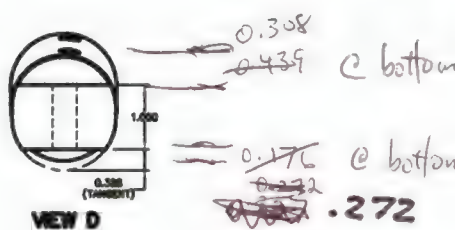
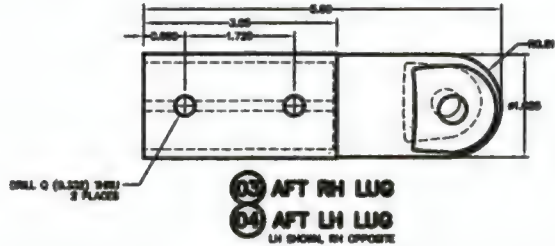
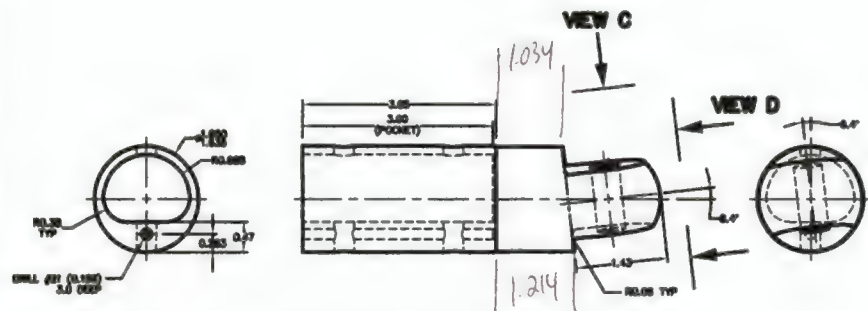
WO# 2016-126

[illegible]

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
01	INITIAL ISSUE		



1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALCOHOL AND EPOXY PRIME ALL ALUMINUM PARTS PRIOR TO ASSEMBLY. ALTERNATE: ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE II.



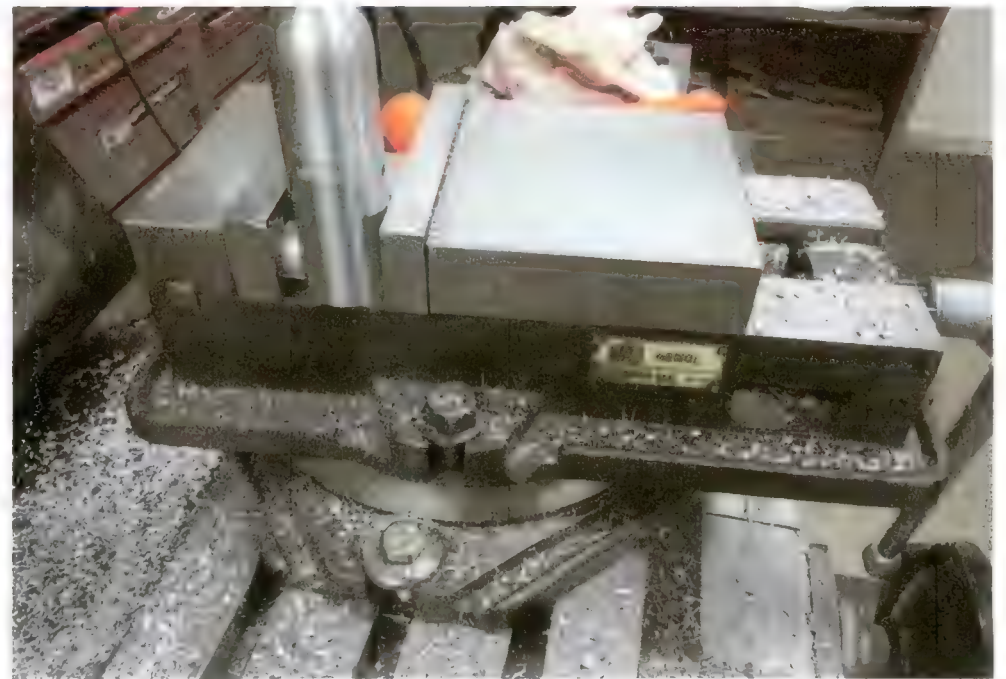
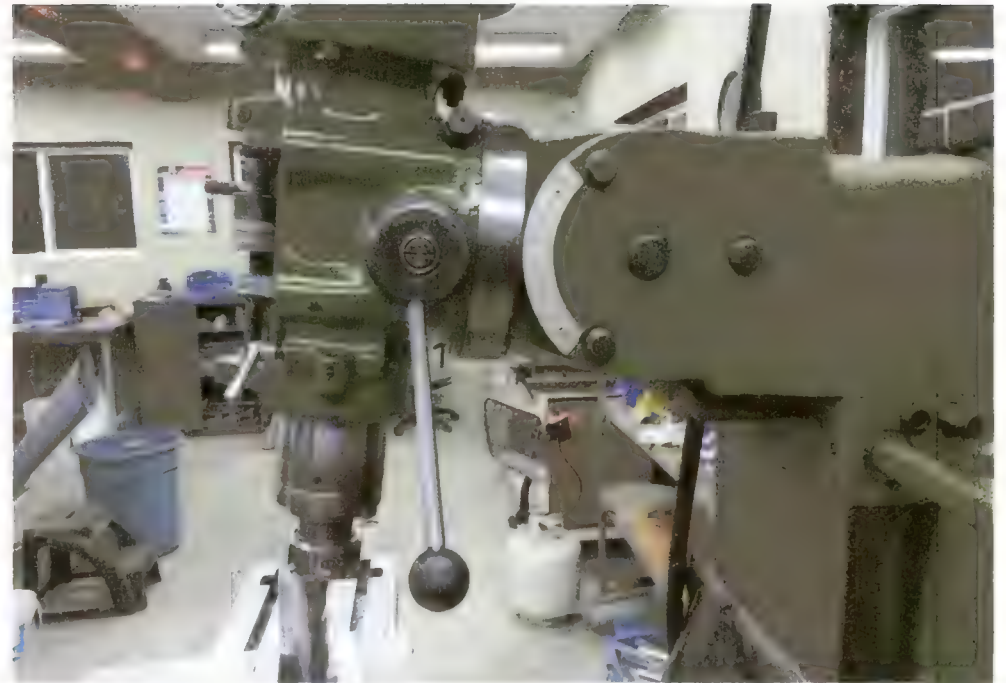
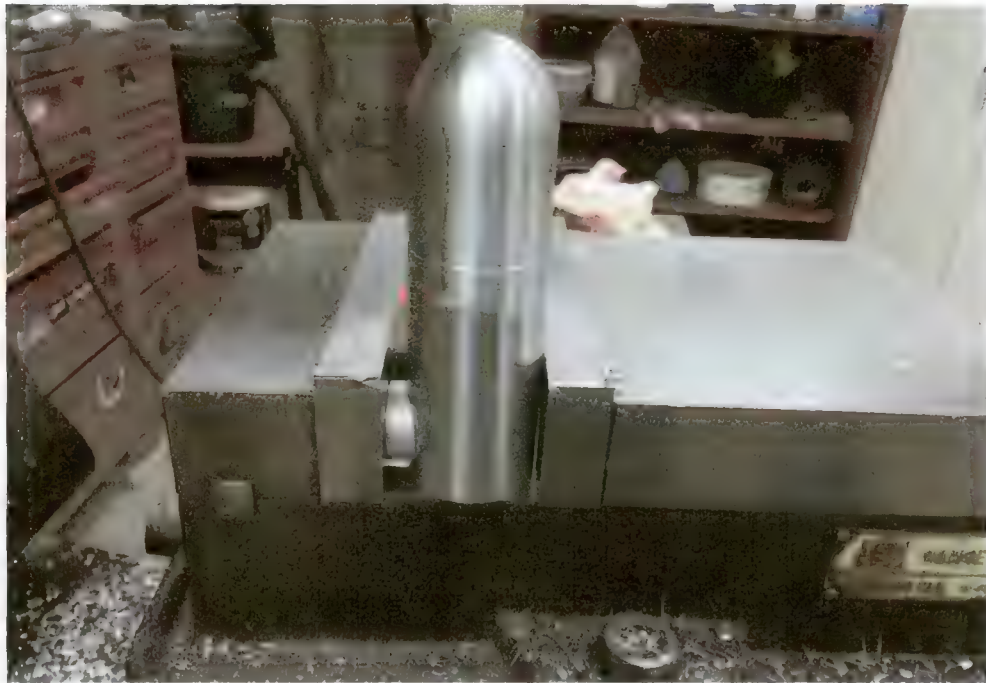
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
0010-01	01	CENTRE LH PLUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-02	02	CENTRE RH PLUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-03	03	AFT LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-04	04	AFT RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-05	05	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-06	06	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-07	07	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-08	08	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-09	09	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-10	10	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-11	11	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-12	12	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-13	13	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-14	14	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-15	15	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-16	16	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-17	17	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-18	18	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-19	19	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-20	20	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-21	21	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-22	22	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-23	23	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-24	24	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-25	25	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-26	26	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-27	27	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-28	28	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-29	29	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-30	30	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-31	31	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-32	32	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-33	33	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-34	34	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-35	35	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-36	36	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-37	37	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-38	38	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-39	39	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-40	40	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-41	41	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-42	42	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-43	43	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-44	44	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-45	45	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-46	46	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-47	47	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-48	48	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-49	49	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-50	50	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-51	51	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-52	52	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-53	53	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-54	54	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-55	55	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-56	56	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-57	57	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-58	58	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-59	59	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-60	60	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-61	61	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-62	62	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-63	63	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-64	64	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-65	65	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-66	66	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-67	67	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-68	68	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-69	69	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-70	70	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-71	71	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-72	72	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-73	73	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-74	74	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-75	75	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-76	76	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-77	77	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-78	78	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-79	79	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-80	80	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-81	81	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-82	82	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-83	83	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-84	84	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-85	85	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-86	86	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-87	87	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-88	88	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-89	89	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-90	90	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-91	91	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-92	92	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-93	93	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-94	94	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-95	95	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-96	96	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-97	97	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-98	98	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-99	99	FORWARD LH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR
0010-100	100	FORWARD RH LUG	AL-7050 ALUMINUM	00-A-220/4	62.0 ROUND BAR

AERO DESIGN LTD.
 10000 WILLOWDALE RD
 POTTERVILLE, ONT. CANADA, M7A 0G8
 TEL: 416-491-1111
 WWW.AERODESIGN.CO

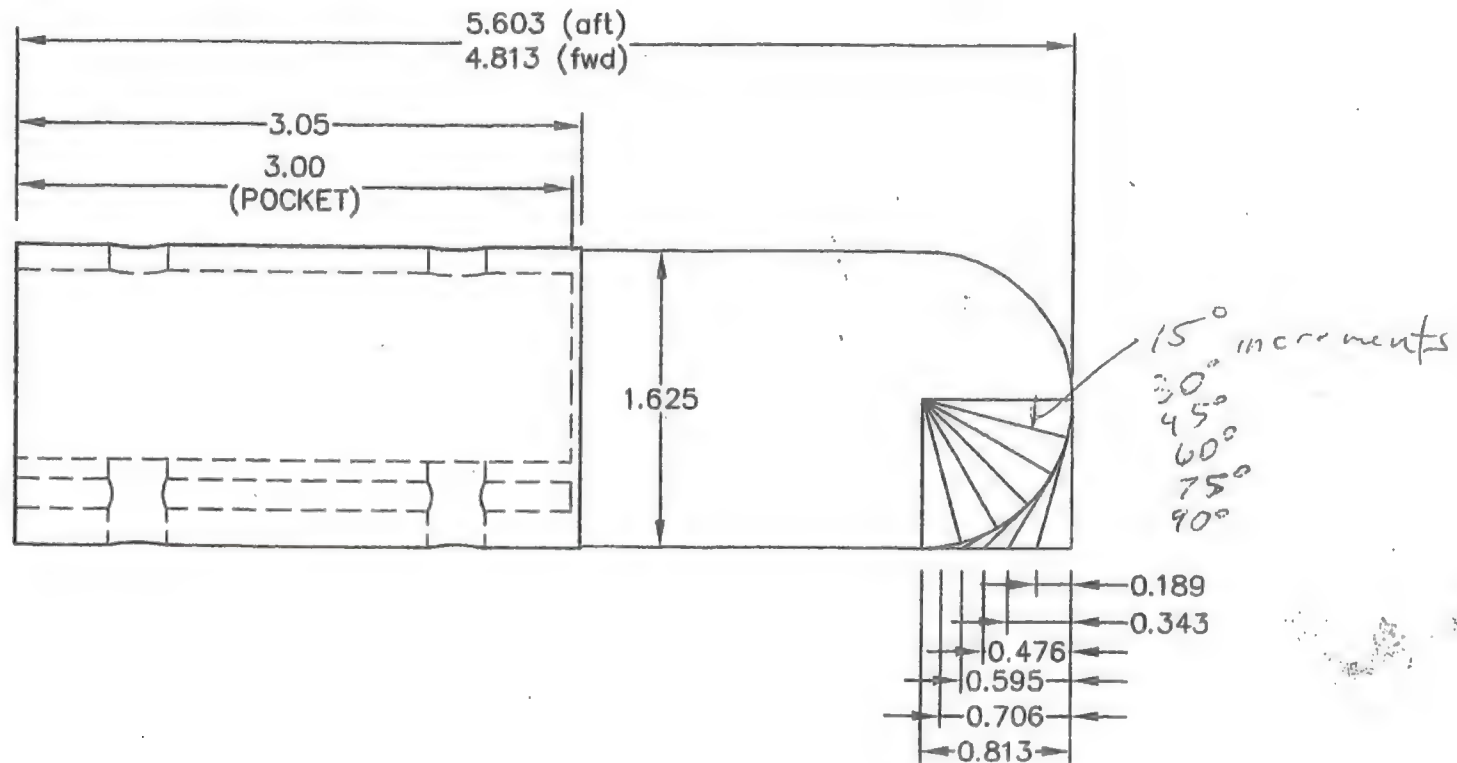
BELL 429 - S/N 57081 & 518.
QUICK RELEASE CARGO BASKET
LUG FABRICATION

SCALE 1:1
 SHEET 1 OF 1
 A1 95940 0





Work aid
drawing 95940





3429 Post S/W 81 Fittings

Setup Notes

Rotate vise 6.4° CW = LH CCW = RH

Rotate head towards operator 6.35°

* Ensure head is aligned to Y axis *

Set ϕ
X:



1 touch one side, set ϕ X

2 touch other side (2.25 nom)

3 Split reading from 2 (1.063 nom)
Set ϕ X

Set ϕ Y



touch close side, set ϕ Y

Set ϕ Z



with cutter @ XO Y 1.063 touch
top.

- vari (2)
- cut paper to protect part from jaws of chuck.
 - wrap part with paper and insert into chuck.
 - set rpm to ~~1380~~ 40 rpm.
 - mark lines on part as per drawing @ .189", .343", .476", .595", .706" and .813" from faced end. using vernier calipers.
 - set rpm to 1380, set cross ~~slide~~ slide to 15° from 90° and make repeated cuts across face until you hit the first line at .189".
 - set cross slide to 30° from 90° and make repeated cuts across face until you hit the second line @ .343".
 - repeat this process for the rest of the lines advancing 15° each time.
 -

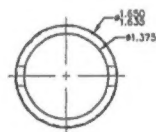
- Part (1)
- insert stop part into 1" collet.
 - cut paper to protect part from jaws of chuck.
 - wrap part with paper and insert into chuck.
 - set rpm to 1380.
 - turn end down to 1.625" for ^{full} length minus 3.05".
 - face end to length as per drawing.

9591 First step

9592 Flats

Cut e 4 7/8

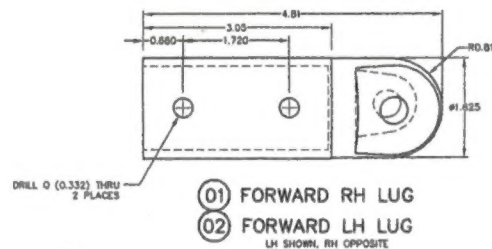
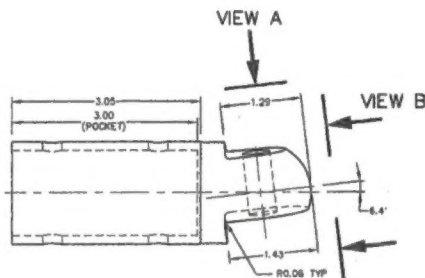
Turn to 4.65
Turn 1 end flat



95930

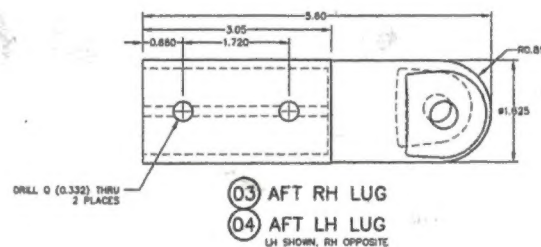
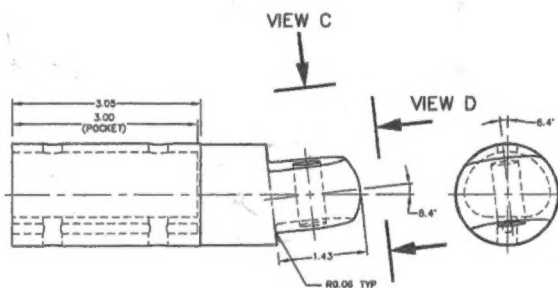
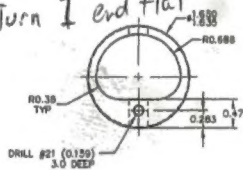
95932

95933



Cut e 5.1/16

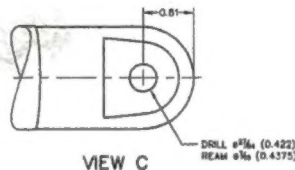
Turn to 5.65
Turn 1 end flat



95930

95931

95933

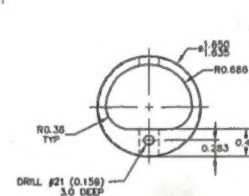


NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALCOHOL AND EPOXY PRIME ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ANODIZE IN ACCORDANCE WITH MIL-A-8625F, TYPE II.

Cut e 4 7/16

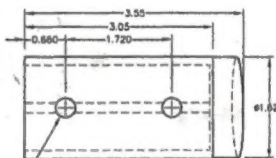
Turn to 4.4 Turn 1 end flat



95930

95931

95933



- (05) CENTRE RH PLUG
- (06) CENTRE LH PLUG

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95940-01	01	CENTRE LH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-02	02	CENTRE RH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-03	03	AFT LH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-04	04	AFT RH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-05	05	FORWARD LH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-06	06	FORWARD RH LUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-07	07	CENTRE LH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR
1	95940-08	08	CENTRE RH PLUG	6061-T6 ALUMINUM	QQ-A-200/B	#2.0 ROUND BAR

APPROVALS		DATE	AERO DESIGN LTD.	
DESIGNED BY	JEFF CLARKE	21 JAN 2014	<p>8888A MALAPPA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604-483-2378 www.aerodesign.ca</p>	
CHECKED BY	JASON KIRKE	21 JAN 2014		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET LUG FABRICATION	
DECIMALS	±0.010	ANGLES	±1/2°	
XX	±0.03			
XX	±0.1			
SCALE 1:1			DWG. NO.	REV.
SHEET 1 OF 1			A1	95940 0

Component Fabrication

95940-01/02 Forward Mounting Lug

Notes:

Date: Sept 2016

Tasks

SCA

1.	Record material PO below	ORM
----	--------------------------	-----

2.	Cut 2" Aluminum Round Bar to 4 7/8", square ends.	DB
	Face one end in the manual Lathe.	JK.
	With the part laying flat with the turned end to the left, set a stop on the right to ensure subsequent parts are placed in the same location.	JK.
	Using standard practices, zero off on the machined face of the part	JK.
	Run Program 95930	JK.
	Remove part and deburr using appropriate methods	JK.
	Install 9591 vice jaw in rear position on the CNC vice.	JK.
	Insert part into the vice with the flat from the previous step to the front and the faced end down.	JK.
	Run Program 95931	JK.
	Remove part and deburr using appropriate methods	JK.
3.	De-burr using appropriate methods	

3.0 deep per. +05/06

Manual Lathe

9.	Insert the stop bar into a 5/8" collet and install	DRM
10.	Install 3 jaw chuck with collet and stop installed.	DRM
	Set the stop so the machined surface is protruding passed the chuck jaws roughly 1/8" inch	DRM
11.	Wrap protective paper around the end previously machined in CNC mill and insert into chuck touching the stop	DRM
12.	Set the speed to 1380 RPM	DRM
13.	Face the end of the part to the finished lenth on drawing number 95940	DRM

2016-126

Sept 2016

14.	Turn the outside diameter to the finished dimension in accordance with drawing number 95940	DRM
15.	Mark the part in accordance with work aid drawing 95940	DRM
16.	Rotate slide to 75 degrees and make the first cut to the first mark	DRM
17.	Rotate slide 15 degrees for each subsequent pass making each cut to the next line until no lines remain.	DRM
	Set speed to 425 RPM	DRM
18.	Using a flat file, blend corners to create rounded end	DRM
19.	Finish using red scotchbright	DRM

Manual Mill

20.	Rotate the vice 6.4 degrees Clockwise = L/H part CCW = R/H part	DRM
21.	Rotate the head up 6.35 degrees	DRM
22.	Ensure the head is perfectly aligned in the Y axis	DRM
23.	Insert clamping tool 95940 -??? Into lower hole and install in vice.	
24.	To set the X axis zero, touch off on both sides and divide by two	DRM
25.	To set the Y axis zero, touch off on the close side	DRM
26.	After step 25 remove table adjustment handle.	
27.	Use quill for depth only.	DRM
28.		
29.		
30.		
31.		
32.		
33.		
34.		
35.		

Completion

N/A

36.	Insert parts into the 100221W welding jig	
37.	Weld parts IAW drawing 100221	
38.	Clean and inspect part	AD02
39.	Tag completed parts IAW Aero Design MPM.	AD02

Material Purchase Order Number 15052Batch Quantity 3 sets